

Work Order ID 86129

86129

Page 1

June-21-12 8:24:08 AM

Item ID: D3770-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tube

Start Date: 21/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/20 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3770	Rev B								
100		0.00							
100	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-cut tube to lenght as per dwg D37702-drill holes thru to finish size as per dwg D3770 Using DT9410,Locate tube on stop labelled #1 and then drill holes labelled #13- deburr								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Chemical Conversion Coat per QSI005 4.1	0.00							
120									
HandFinish	Memo	0.00							
Hand Finishing									

4 ~~0~~ FF 12-06-28

(CC)

4 Hg 12.7.3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 21/06/2012 Start Qty: 4.00

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC3- Inspect Part Finish

0.00

130

QC Memo

0.00

Quality Control

12/7/3 (4)

140 Identify as per dwg & Stock Location **SI 250**

0.00

140

Packaging Memo

0.00

Packaging

4x 12-7-3

150 QC21- Final Inspection - Work Order Release

0.00

150

QC Memo

0.00

Quality Control

12/7/4

ME 12-07-03

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Picklist Print

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Work Order ID: 86129

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Parent Item: D3770-1

D3770-1

Parent Item Name: Tube

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A 08-07-21 revB as per dwg DD verified by:EC

IPP Rev:B Added Drilling Tooling 08-08-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.000W065		Purchased		No		100	f	85.9465	1.1358	4.782316			

M6061T6T1 000W065

6061T6 RD TUBE 1.00 x .065w

**

FF 12-06-28

Location

MAT015

114089

116720

117983

122146

Loc Qty

85.9465469

0.3114

1.2

24.4351469

60

Loc Code

4.782316

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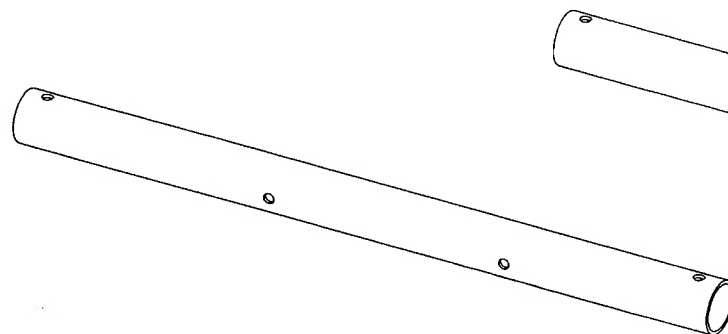
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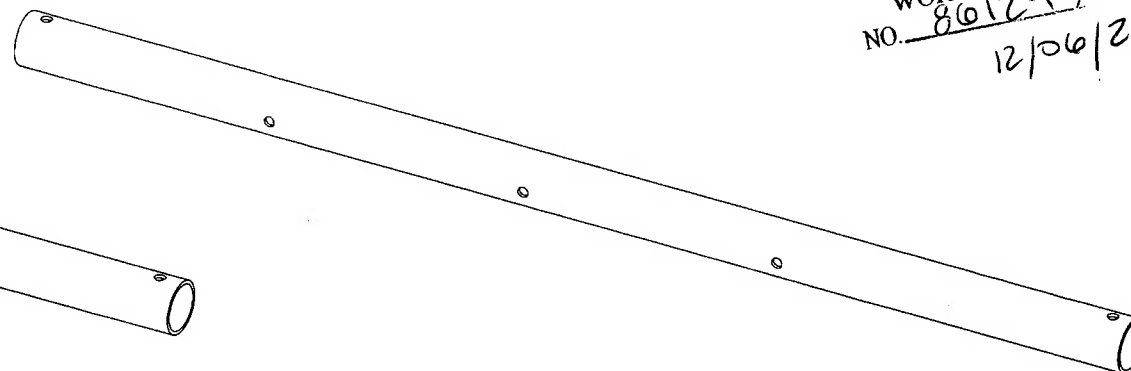
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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 80129 MCT
12/06/21



D3770-1 TUBE



D3770-3 TUBE

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3770-1, 0.25 lbs
D3770-3, 0.40 lbs

B	CHANGE HOLES SIZE TO 0.201	HS	08.05.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	PC	DRAWING NO.	REV. B
MFG. APPR.	PC	D3770	SHEET 1 OF 3
APPROVED	PC	TITLE	SCALE
DE APPR.	PC	TUBE	NTS
DATE	08.06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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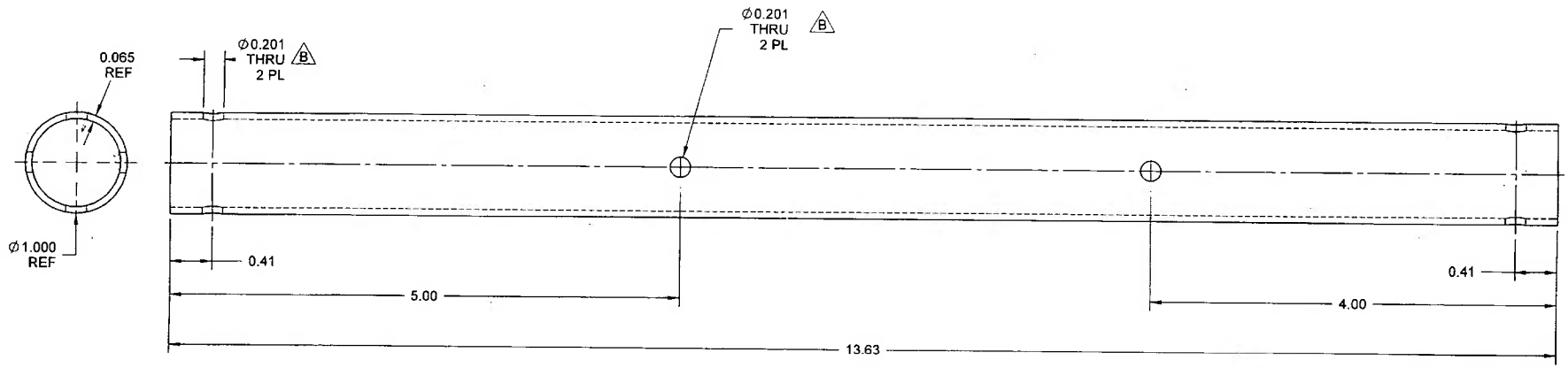
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26129



D3770-1 TUBE

RELEASED
08.07.10

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
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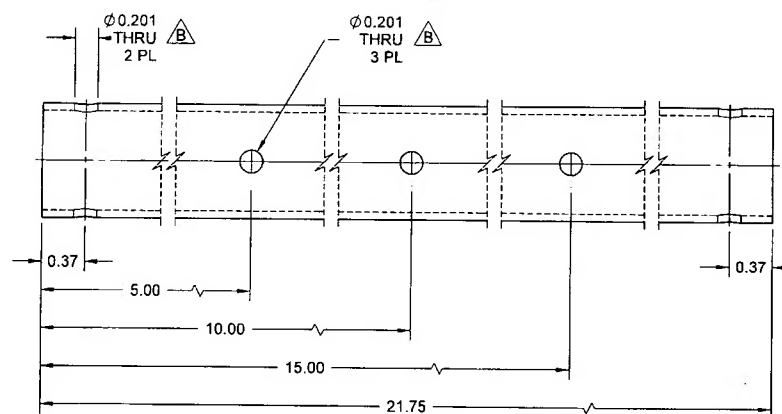
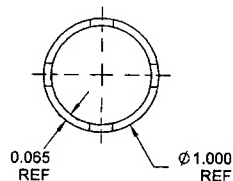
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D3770-3 TUBE

RELEASED
11-05-07-10/11/12

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